

Date: Tuesday, 19/08/2008 4:03:46 PM
 User: Julie Lecocq

Process Sheet

| | | | | | | |
|-----------------------|---|--|--------------|----------------------------------|---------------|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | Drawing Name | : DECK PLATE,FWD ,350 LITTER KIT | | |
| Job Number | : 41423 | | | | | |
| Estimate Number | : 11104 | | | | | |
| P.O. Number | : | | | Part Number | : D2364 | |
| This Issue | : 19/08/2008 | | S.O. No. | Drawing Number | : D2364 REV.F | |
| Prsht Rev. | : NC | | | Project Number | : N/A | |
| First Issue | : / / | | Type | Drawing Revision | : F | |
| Previous Run | : 39239 | | | Material | : | |
| Written By | : | | | Due Date | : 08/09/2008 | |
| Checked & Approved By | <u>JUL 08.8.9</u> | | | Qty: | 6 Um: Each | |
| Comment | : EST. REV. E 00.06.26 Removed P/O for powder coat EC Est Rev:F Now On Waterjet 06-07-03 JLM | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : | |
|---------|-----------------------|---|---------------------------------|
| 1.0 | M2024T3S063 | 2024-T3 .063 sheet | |
| | | Comment: Qty.: 0.6792 sf(s)/Unit Total : 4.0755 sf(s) 2024-T3 .063 Aluminum sheet (M2024T3S063) Batch: <u>108415</u> | |
| 2.0 | WATER JET | FLOW WATER JET | |
| | | Comment: FLOW WATER JET 1-Cut as per Dwg D2364 Dwg Rev: <u>F</u> Prog Rev: <u>F</u> | <u>B 8-8-22</u> <u>7</u> |
| | | 2-Deburr if necessary | |
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE | |
| | | <u>B 8-8-22</u> | |
| | | Comment: INSPECT PARTS AS THEY COME OFF MACHINE | |
| 4.0 | QC8 | SECOND CHECK | |
| | | <u>S 08/09/25 +7</u> | |
| | | Comment: SECOND CHECK | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1 | |
| | | Comment: SMALL & MEDIUM FAB RESOURCE 1 | |
| | | 1- counter sink holes as per dwg D2364 | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:03:46 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: DECK PLATE,FWD ,350 LITTER KIT

Job Number: 41423

Part Number: D2364

Job Number:



Seq. #:

Machine Or Operation:

Description :

2- deburr if necessary

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



(7X)

Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

m-f

08/09/26

8.0 POWDER COATING

POWDER COATING



(7X)

M105642

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

8:10°F

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320

8:40

m-f 08/09/27

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

C 8/9/29

10.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 186

R P 8/9/29 (7)

11.0 QC21

FINAL INSPECTION/W/O RELEASE



08/09/30 (7)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 08-09-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | |
|--|--------------|-------------|
| DART AEROSPACE LTD | Work Order: | 41423 |
| Description: Litter Deck Plate Kit (350) | Part Number: | D2364 |
| Inspection Dwg: D2364 Rev: F | | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 6.624 | +/-0.010 | 6.631 | X | | | |
| Ø0.171 | +0.005/-0.000 | 172 | X | | | |
| 0.354 | +/-0.010 | 356 | X | | | |
| 11.242 | +/-0.010 | 11.240 | X | | | |
| 3.031 | +/-0.010 | 3035 | X | | | |
| 1.903 | +/-0.010 | 1.905 | X | | | |
| 1.128 | +/-0.010 | 1.129 | X | | | |
| 0.354 | +/-0.010 | 357 | X | | | |
| 1.340 | +/-0.005 | 1.347 | X | | | |
| 2.326 | +/-0.010 | 2.329 | X | | | |
| 3.312 | +/-0.010 | 3.317 | X | | | |
| 4.298 | +/-0.010 | 4.298 | X | | | |
| 5.284 | +/-0.010 | 5.284 | X | | | |
| 6.151 | +/-0.010 | 6.155 | X | | | |
| 6.270 | +/-0.010 | 6.273 | X | | | |
| 0.354 | +/-0.010 | 356 | X | | | |
| 3.031 | +/-0.010 | 3.035 | X | | | |
| Ø0.656 | +0.005/-0.000 | 657 | X | | | |
| 5.003 | +/-0.010 | 5003 | X | | | |
| 4.605 | +/-0.010 | 4.606 | X | | | |
| 1.776 | +/-0.010 | 1.778 | X | | | |
| 0.980 | +/-0.010 | 983 | X | | | |
| 4.487 | +/-0.010 | 4.488 | X | | | |
| 7.192 | +/-0.010 | 7.195 | X | | | |
| 7.567 | +/-0.010 | 7.567 | X | | | |
| 7.942 | +/-0.010 | 7.950 | X | | | |
| Ø0.191 | +0.005/-0.000 | 193 | X | | | |
| Ø0.197 | +0.005/-0.000 | 198 | X | | | |
| 11.145 | +/-0.010 | 11.145 | X | | | |
| 12.181 | +/-0.010 | 12.181 | X | | | |
| 11.378 | +/-0.010 | 11.378 | X | | | |
| 11.776 | +/-0.010 | 11.776 | X | | | |
| 12.173 | +/-0.010 | 12.173 | X | | | |
| 4.690 | +/-0.010 | 4.695 | X | | | |
| 0.250 | +0.005/-0.000 | 251 | X | | | |
| 3.141 | +/-0.010 | 3.149 | X | | | |
| 0.171 | +0.005/-0.000 | 173 | X | | | |

| | | | | | |
|--------------|--------|-------------|--------|---------------------|-----|
| Measured by: | HB | Audited by: | | Prototype Approval: | N/A |
| Date: | 8-8-26 | Date: | 080826 | Date: | N/A |

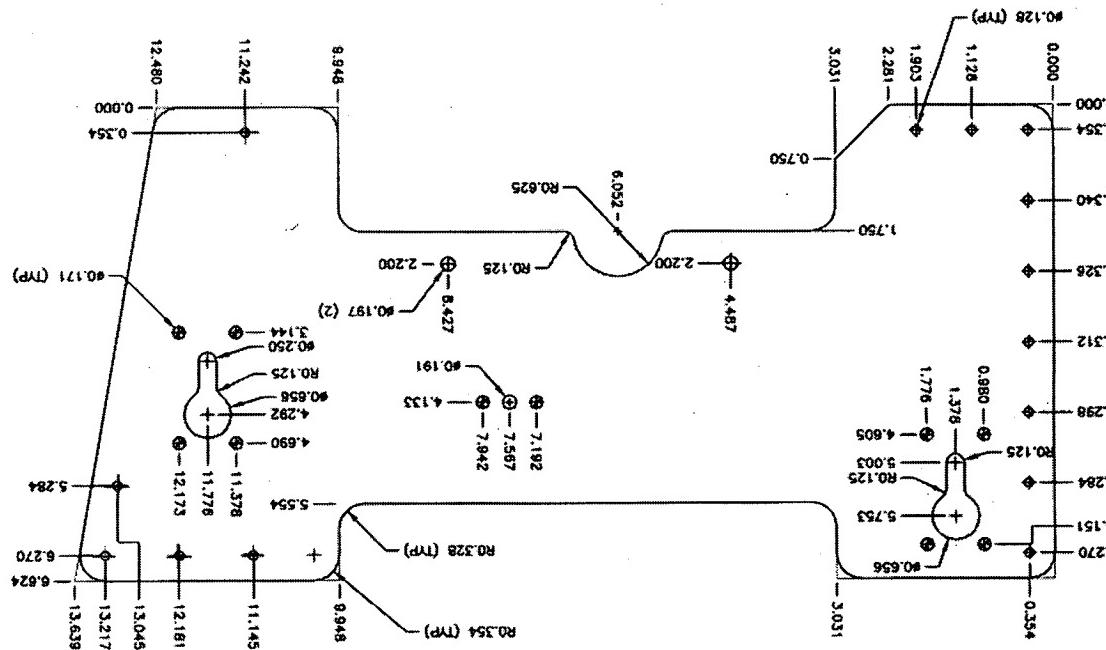
| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------|------------|----------|
| A | 04.06.25 | New Issue P/O D350-616-015 | KJ/JLM | |
| B | 08.05.28 | 7.567 dimension revised | KJ/DD | |

| | | |
|----------|------------------------|---|
| DESIGN | DRAWN BY <i>KE</i> | DART AEROSPACE LTD |
| CHECKED | APPROVED <i>JW</i> | HAWKESBURY, ONTARIO, CANADA |
| DATE | D2364 | DRAWING NO. |
| | | TITLE |
| 98.06.19 | LITTER DECK PLATE, 350 | SCALE |
| A | 95.01.14 | NEW ISSUE |
| B | 95.02.09 | MOVED KEYWAY |
| D | 95.03.06 | 0.191 WAS 0.197 |
| E | 95.10.06 | GEOMETRY CHANGES |
| F | 98.06.19 | 0.063-0.071 THICK WAS 0.071 (TSR A371) |



RELEASED
R 06/22 KG

COUNTER SINK HOLES:
 ♦ C-SINK Ø0.308 x 100. (UPDATED From 9 to 14 HOLES BT OS 99.03.01 TO CORRECT CAD ERROR)
 ♦ C-SINK Ø0.225 x 100. (UPDATED From 9 to 14 HOLES BT OS 99.03.01 TO CORRECT CAD ERROR)



MATERIAL: 2024-T3 (QD-A-250/5) 0.063-0.071 THICK
 FINISH: POWDER COAT BLACK CRINKELE (4.3.5.3) PER DART QSI 005 4.3
 TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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